

Tuesday, 04/11/2008 8:34:04 AM

User:

Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : PANEL--ROTOR BRAKE KIT

Job Number : 43178

Estimate Number : 13584

P.O. Number :

Part Number : D38213

This Issue : 04/11/2008 S.O. No. :

Drawing Number : D38213 UNDER REVIEW 08.11.05 RH

Prsht Rev. : NC

Project Number : IN0002

First Issue : / / Type : R&amp;D THERMOFORMING

Drawing Revision : A UNDER REVIEW

Previous Run : 42066

Material : MKYDEX6185S80P362015

Written By : \_\_\_\_\_

Due Date : 14/11/2008 Qty: 2 Um: EACH

Checked &amp; Approved By : \_\_\_\_\_

Comment : Est. A New Issue 08/09/17 DL

Additional Product

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

04/11/2008 DL

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MKYDEX6185S80P362015

Kydex velour matte, ivory



Comment: Qty.: 13.2489 sf(s)/Unit Total : 26.4978 sf(s)

Kydex velour matte, ivory

M109703

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/04 WH

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/04 WH

4.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3821-3 and folio (FTA 9054 Prototype ) using tool DT 9054

Dwg. Rev. A UNDER REVIEW

Folio Rev. A

08/11/04 DH

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/04 WH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 04/11/2008 8:34:04 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL--ROTOR BRAKE KIT

Job Number: 43178

Part Number: D38213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*BB 08/11/17*

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*BB 08/11/17 x2*

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

*08.12.01*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*N/A NOT FOR STOCK*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08.12.01 PROTOTYPE*

Job Completion



*08.12.24*  
**POSITIVE RECALL**  
**EFFECTIVE 08.12.04**  
**RELEASED** **DATE**  
*cancel*

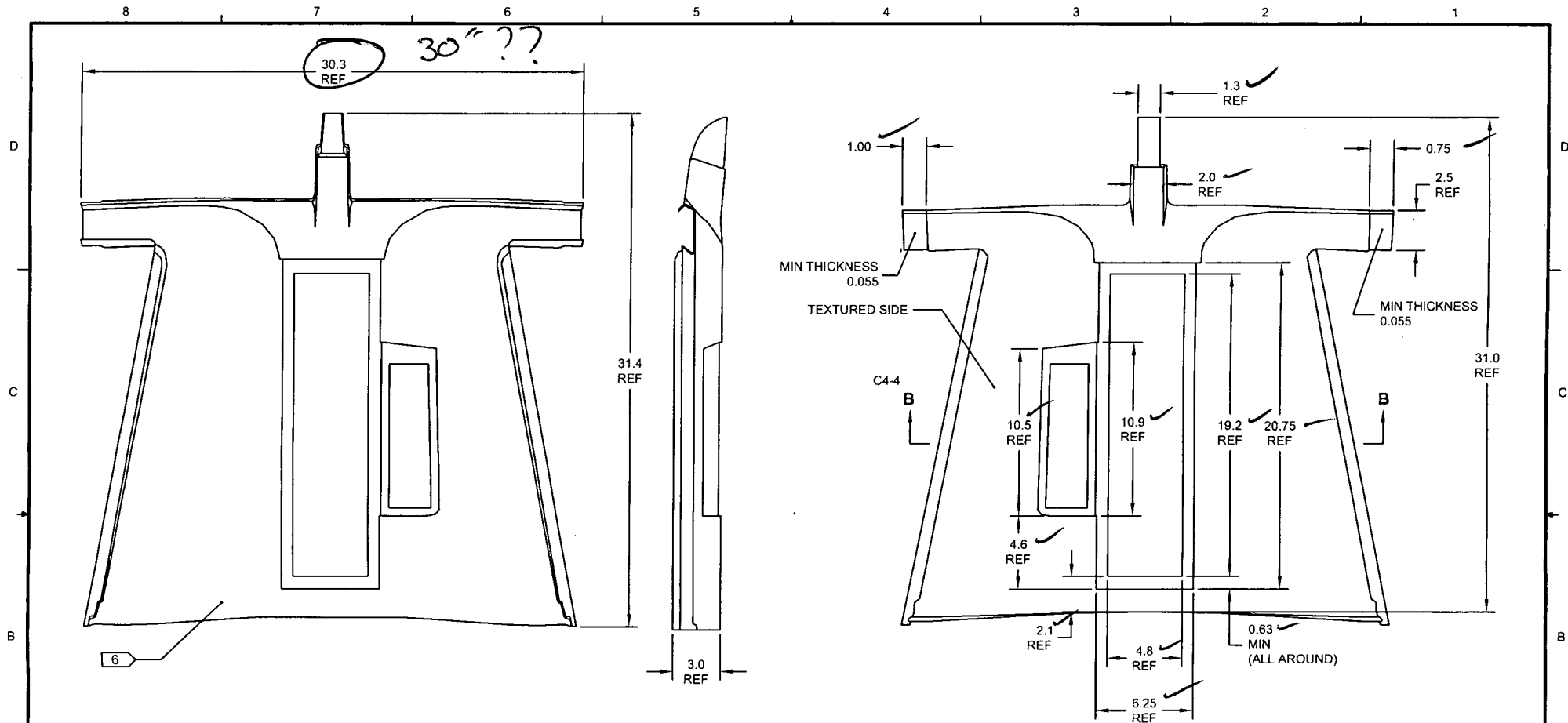
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3821-3 PANEL, WITH ROTOR BRAKE**

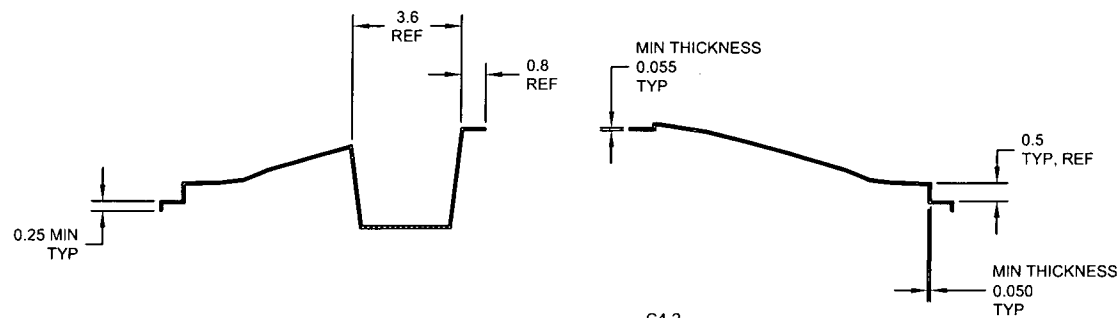
**NOTES:**

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3821-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.4 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9054 PER DART QSI 022. TRIM PER MOLD

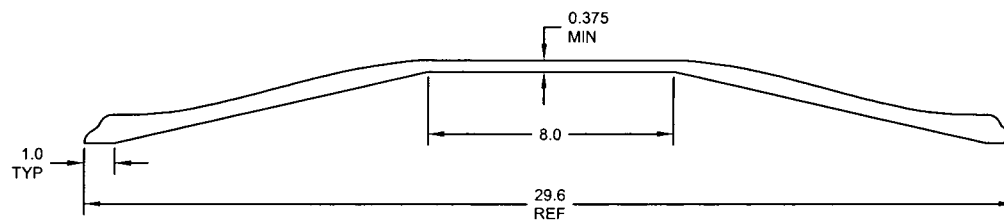
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
**PH 08.11.25**

DESIGN	<b>D3821</b>	<b>DART AEROSPACE LTD</b>
DRAWN	<b>PH</b>	<b>HAWKESBURY, ONTARIO, CANADA</b>
CHECKED		DRAWING NO. <b>D3821</b> REV. A
MFG. APPR.		SHEET 2 OF 4
APPROVED		TITLE <b>PANEL</b> SCALE <b>NTS</b>
DE APPR.		
DATE	<b>08.09.29</b>	

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**SECTION B-B** C4-2



**VIEW D** C4-2

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING  
 08.11.25

DESIGN	RS	<b>DART AEROSPACE LTD</b>	
DRAWN	RS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3821	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	08.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

# Receiving Report

Date:

**Batch No:**

**Supplier:**

Dart P/O:

**Packing Slip:**

**Yes**

No

Invoice:

**Yes**

**No**

**Receipt:**

**Cash**

Cr

**Release Note Attached:**

Yes

~~No~~

N/A

**Waybill Attached:**

Yes

No

• **costs**

**Shipment Complete**

~~Yes~~

No

N/A

## QC6 Inspection

N/A

## Work Order

N/A

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

**Initials of receiver (if shipment OK)**

Level 12

Admin:

### Location



**SABIC Polymershapes**

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 8000/27

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL  
BRANCH MANAGER



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43178
<b>Description:</b> Panel - with Rotor Brake / Prototype.		<b>Part Number:</b> D3821-3
<b>Inspection Dwg:</b> D3821	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> BB	<b>Date:</b> 08/11/27
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55 (Typ)	min	0.060	✓			
0.63 (Typ)	min	0.63	✓			
4.8 (Ref)		4.8	✓			
19.2 (Ref)		19.25	✓			
10.9 (Ref)		10.9	✓			
10.5 (Ref)		10.5	✓			
4.6 (Ref)		4.63	✓			
2.1 (Ref)		2.065	✓			2.1 on other side
6.25 (Ref)		6.25	✓			From Top Radius.
20.75 (Ref)		20.75	✓			" "
2.0 (Ref)		2.0	✓			
1.3 (Ref)		1.313	✓			

<b>Measured by:</b> BB	<b>Date:</b> 08/11/27
<b>Audited by:</b>	<b>Date:</b> 08/11/27
<b>Prototype Approval:</b> PH	<b>Date:</b> 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD		Work Order:	43178
Description: Panel - with Rotor Brake / Prototype		Part Number:	03821-3
Inspection Dwg: D3821 Rev: A		Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

2 of 2

☒ First Article ☒ Prototype

## THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: <u>08/11/27</u>
------------------------	-----------------------

## TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	± 0.030	0.768	✓			
1.00	± 0.030	1.00	✓			
2.5 (Ref)		2.568	✓			
31.0 (Ref)		31.032	✓			
30.3 (Ref)		30.		✓		Too much flex, but minimum 30"
29.6 (Ref)		29.6	✓			

Measured by: <u>BB</u>	Date: <u>08/11/27</u>
Audited by: <u>[Signature]</u>	Date: <u>08/11/27</u>
Prototype Approval: _____	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	